

Work Order ID 53975

November 24, 2009 2:30:12 PM



Page 1

Item ID:	D3574-2	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Cabin Floor Protector					
Start Date:	25/11/2009	Start Qty:	4.00	Cust Item ID:		
Required Date:	02/12/2009	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-11-24	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3574	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3574								
	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

RB 9-11-30

4

RB 9-11-30

REL

f

2) 8 11/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date:	02/12/2009	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
	Identify as per dwg & Stock Location: _____								
Packaging	Memo	0.00							
Packaging									

Handwritten: 278 on 12/01 (4)

Handwritten: 461

Handwritten: 9/12/1 (4) 5y

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November 24, 2009 2:30:12 PM



Accept

**Setup Start**

B

Stop



Start Date: 25/11/2009 **Start Qty:** 4.00 ..



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

**Accept
Qty**

Reject
Qty**Reject
Number**

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/07

BH 09121

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 24, 2009 2:30:19 PM

Page 1

Work Order ID: 53975



Parent Item: D3574-2RevB



Parent Item Name: Cabin Floor Protector

Start Date: 25/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,509.138	134.4672			
GE PLASTICS LEXAN SHEET												



125-11-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

2509.138698

103106

7.8

105330

54

109455

46.695

111710

329.893632

112585

2070.75007

112585

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	53975
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.005	X			
7.37	+/-0.030	7.37	*			
10.75	+/-0.030	10.75	*			
11.00	+/-0.030	11.00	*			
15.25	+/-0.030	15.25	*			
25.87	+/-0.030	25.87	*			
39.75	+/-0.030	39.75	*			
44.75	+/-0.030	44.75	*			
53.51	+/-0.030	53.51	*			
63.50	+/-0.030	63.50	*			
65.25	+/-0.030	65.25	*			
10.75	+/-0.030	10.75	*			
11.00	+/-0.030	11.00	*			
14.75	+/-0.030	14.75	*			
25.50	+/-0.030	25.50	*			
25.75	+/-0.030	25.75	*			
26.00	+/-0.030	26.00	*			
32.87	+/-0.030	32.87	*			
38.81	+/-0.030	38.81	*			
45.00	+/-0.030	45.00	*			
48.25	+/-0.030	48.25	*			
58.38	+/-0.030	58.38	*			
61.25	+/-0.030	61.25	*			
64.13	+/-0.030	64.13	*			
64.63	+/-0.030	64.63	*			
66.50	+/-0.030	66.50	*			
7.50	+/-0.030	7.50	*			
9.50	+/-0.030	9.50	*			
10.38	+/-0.030	10.38	*			
10.88	+/-0.030	10.88	*			
14.50	+/-0.030	14.50	*			
16.56	+/-0.030	16.56	*			
18.75	+/-0.030	18.75	*			
24.13	+/-0.030	24.13	*			

DART AEROSPACE LTD		Work Order:	
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.56	X			
30.50	+/-0.030	30.50	X			
33.88	+/-0.030	33.88	X			
39.50	+/-0.030	39.50	X			
40.25	+/-0.030	40.25	X			
43.50	+/-0.030	43.50	X			
46.60	+/-0.030	46.60	X			
7.63	+/-0.030	7.63	X			
11.00	+/-0.030	11.00	X			
11.50	+/-0.030	11.50	X			
16.75	+/-0.030	16.75	X			
19.00	+/-0.030	19.00	X			
22.50	+/-0.030	22.50	X			
30.75	+/-0.030	30.75	X			
32.63	+/-0.030	32.63	X			
32.75	+/-0.030	32.75	X			
35.13	+/-0.030	35.13	X			
36.50	+/-0.030	36.50	X			
40.00	+/-0.030	40.00	X			
41.88	+/-0.030	41.88	X			
43.63	+/-0.030	43.63	X			
0.125	+/-0.010	0.130	X			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-11-30	Date: 09/11/30	Date:	N/A

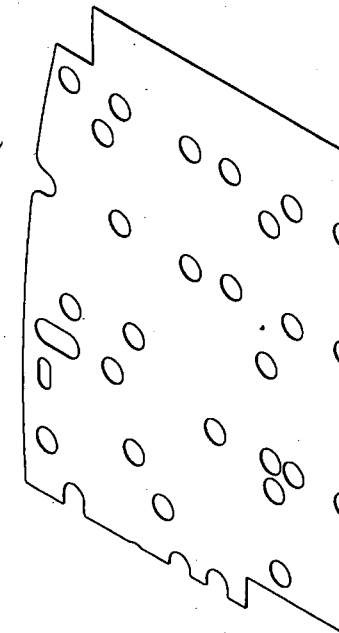
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

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ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 53975
BH 09-11-24

0.125
REF



RELEASED
09/03/07

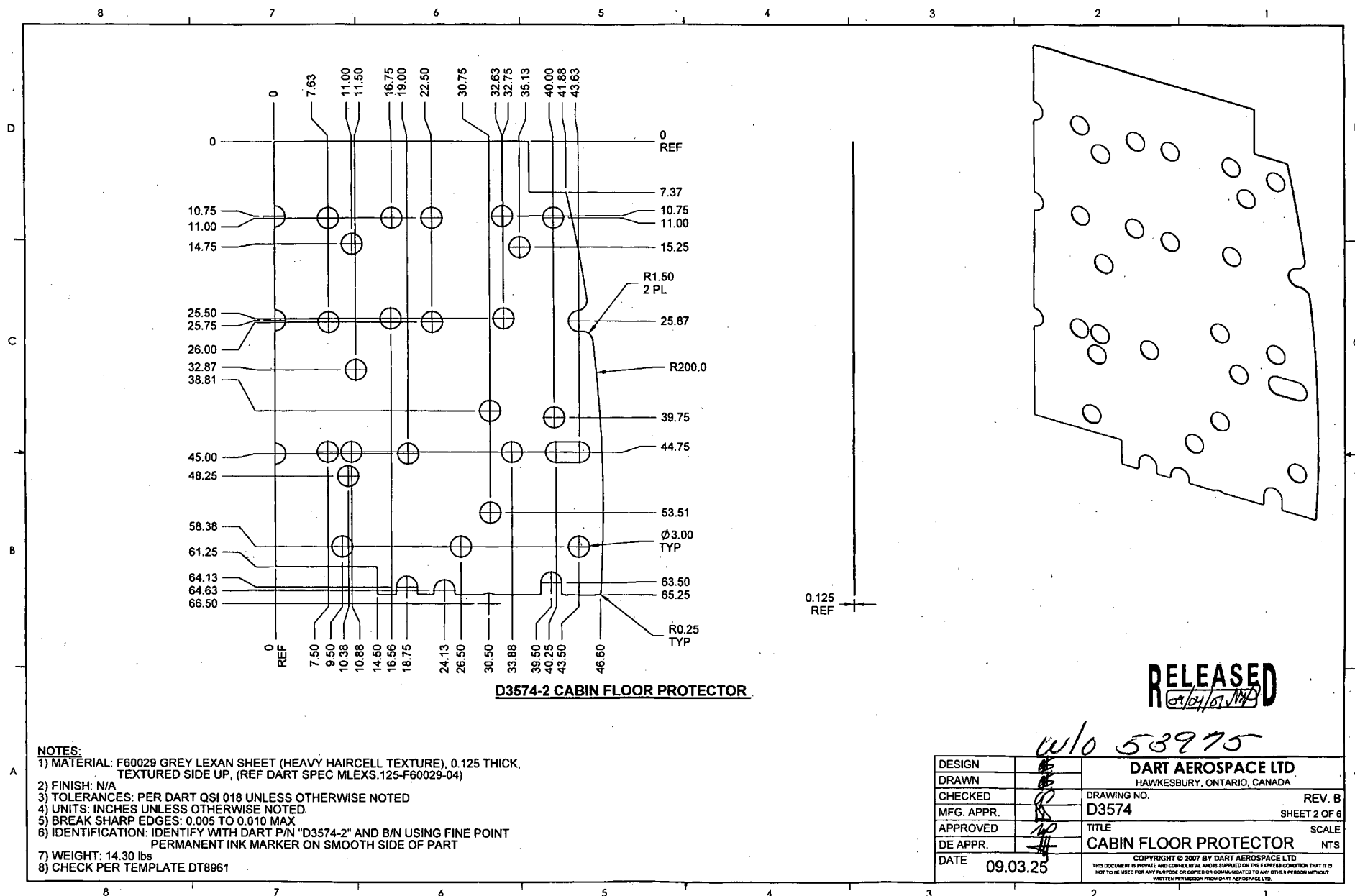
D3574-1 CABIN FLOOR PROTECTOR

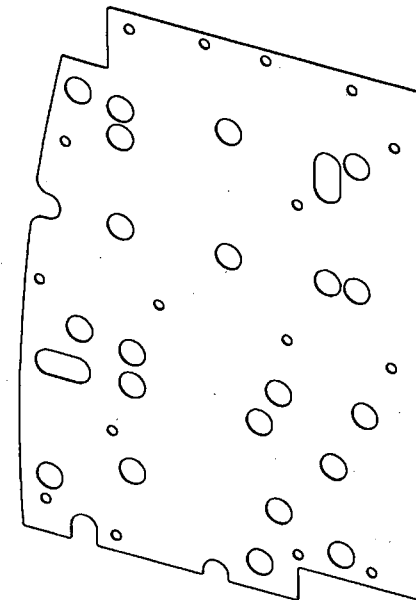
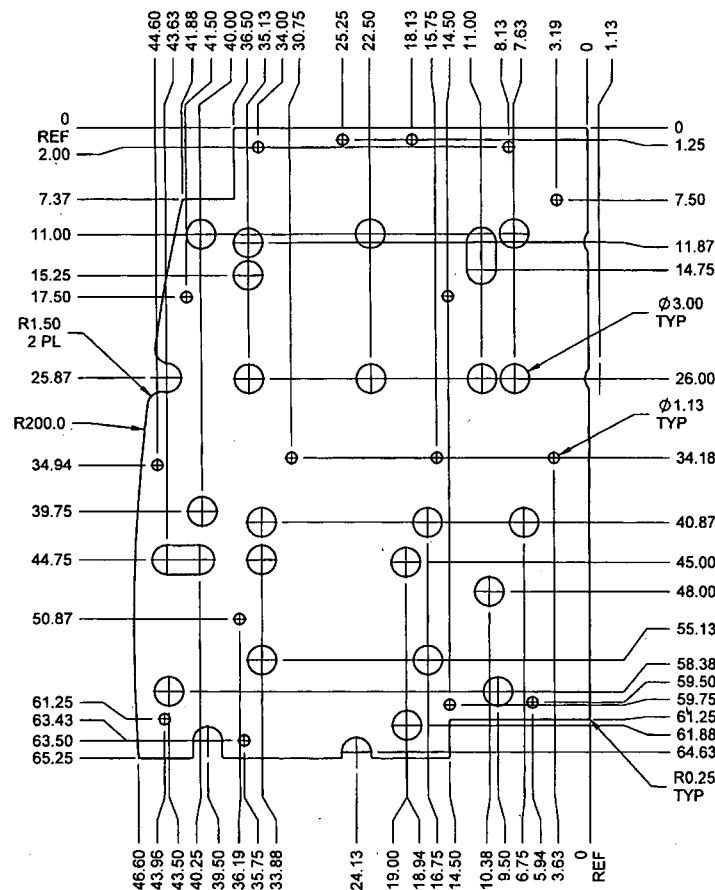
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

B	ADD CUT-OUT TO -1/5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3574	REV. B
TITLE CABIN FLOOR PROTECTOR	SCALE NTS
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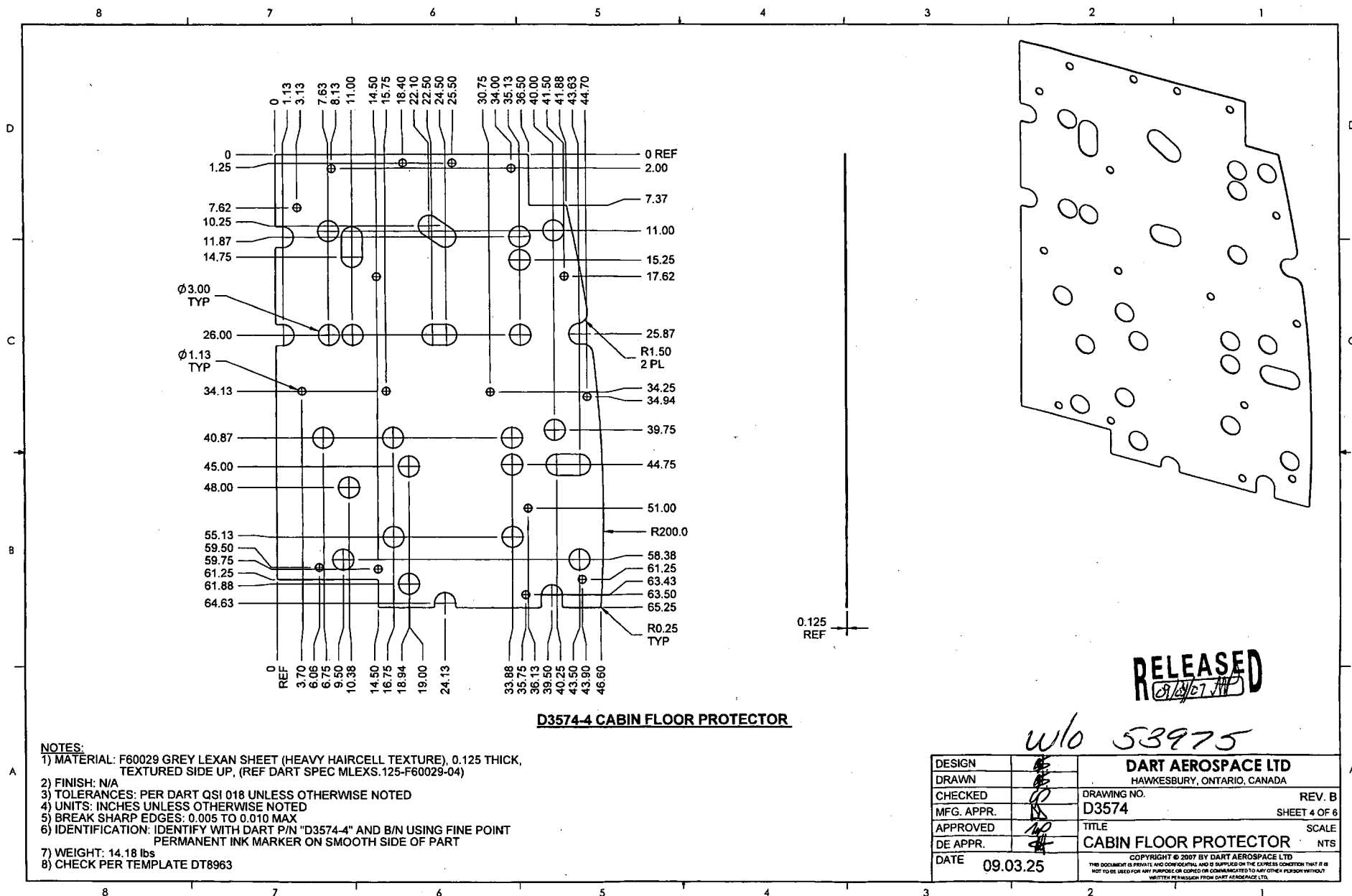
D3574-3 CABIN FLOOR PROTECTOR

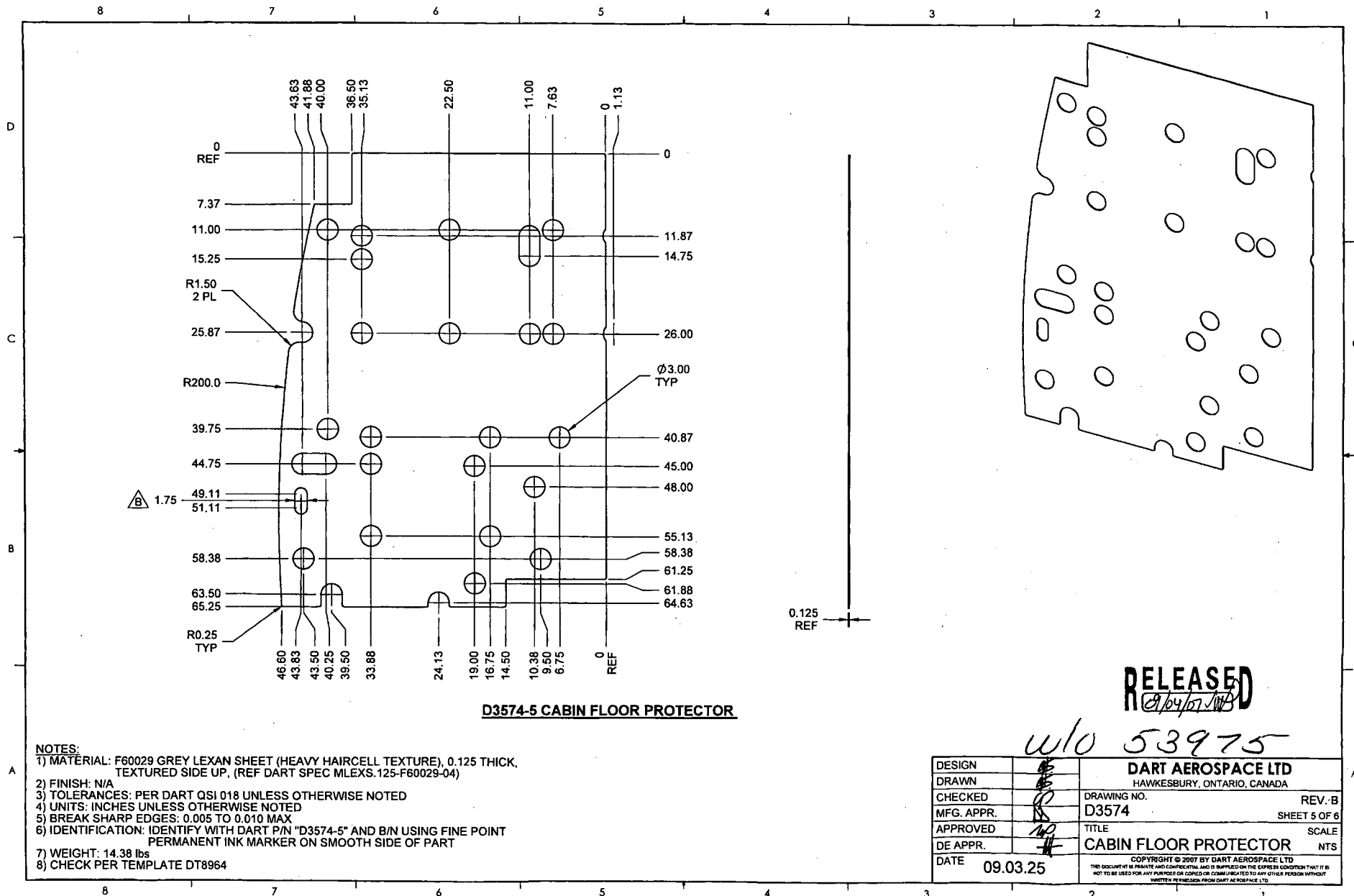
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

RELEASED
3/14/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
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01/04/07 JMB

w/lo 53975

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MFG. APPR.		D3574	SHEET 5 OF 6
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